

Date: Monday, 12/5/2005 9:24:31 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 25099	
Estimate Number : 10384	
P.O. Number : PIA	Part Number : D3195043
This Issue : 12/5/2005 S.O. No. : PIA	Drawing Number : D3195 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/5/2005 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : PIA	Material : PIA
Written By : <u>See comment below</u>	Due Date : 12/20/2005
Checked & Approved By : <u>See comment below</u>	Qty : 5 Um : Each
Comment : Est Rev:A New Issue 05-11-08 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.3150 f(s)/Unit Total : 1.5750 f(s)
 Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11)
 (M6061T6B1.250x1.500)
 Identify for D3195-3
 Batch: M18600 18" J.G 05/12/06 5

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: (1.250" x 1.500") x 3.60" long J.G 05/12/06 5

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3
 2-Deburr Pto. J.G 05/12/06 5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.G 05/12/06 5

5.0	QC8	SECOND CHECK J.L
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/01/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/10	# 3.0	one part scrapped first Run: origin was in the wrong place.	AS 05/12/10	Scrap and Destroy and Replace. mark better in fo. 10.	EP 05/12/10	AS 05.12.10	AS 05.12.10	AS 05.12.10

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:24:31 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25099

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 12/11/05 5

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 05/12/13 5

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/01/04

9.0

D31957

Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s):

Pick:

Qty Part Number Description Batch

1 D3195-7 PAD B20359

SB 06/01/04

5

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3195-7 into D3195-13as per Dwg D3195Pick:

Qty Description Batch

A/RContact Cement M 116194

Identify as D3195-043

SB 06/01/04

5

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 06.01.05

5

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 90

10 06/01/05

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/5/2005 9:24:32 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 25099

Part Number: D3195043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SP 06/01/06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	25094
Description: Bracket		Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.433	-			
1.265	+/-0.010	1.261	-			
R0.37	+/-0.030	0.37	-			
Ø0.277	+0.005/-0.000	0.277	/			
2.677	+/-0.005	2.674	-			
0.242	+/-0.010	0.243	-			
0.377	+/-0.010	0.379	-			
0.500	+/-0.010	0.496	-			
R0.188	+/-0.010	0.188	-			
0.250	+/-0.010	0.247	-			
0.882	+/-0.010	0.873	-			
1.250	+/-0.010	1.252	✓			
0.500	+/-0.010	0.497	-			
Ø0.191	+0.005/-0.000	0.191	-			
1.000	+/-0.010	1.00	-			

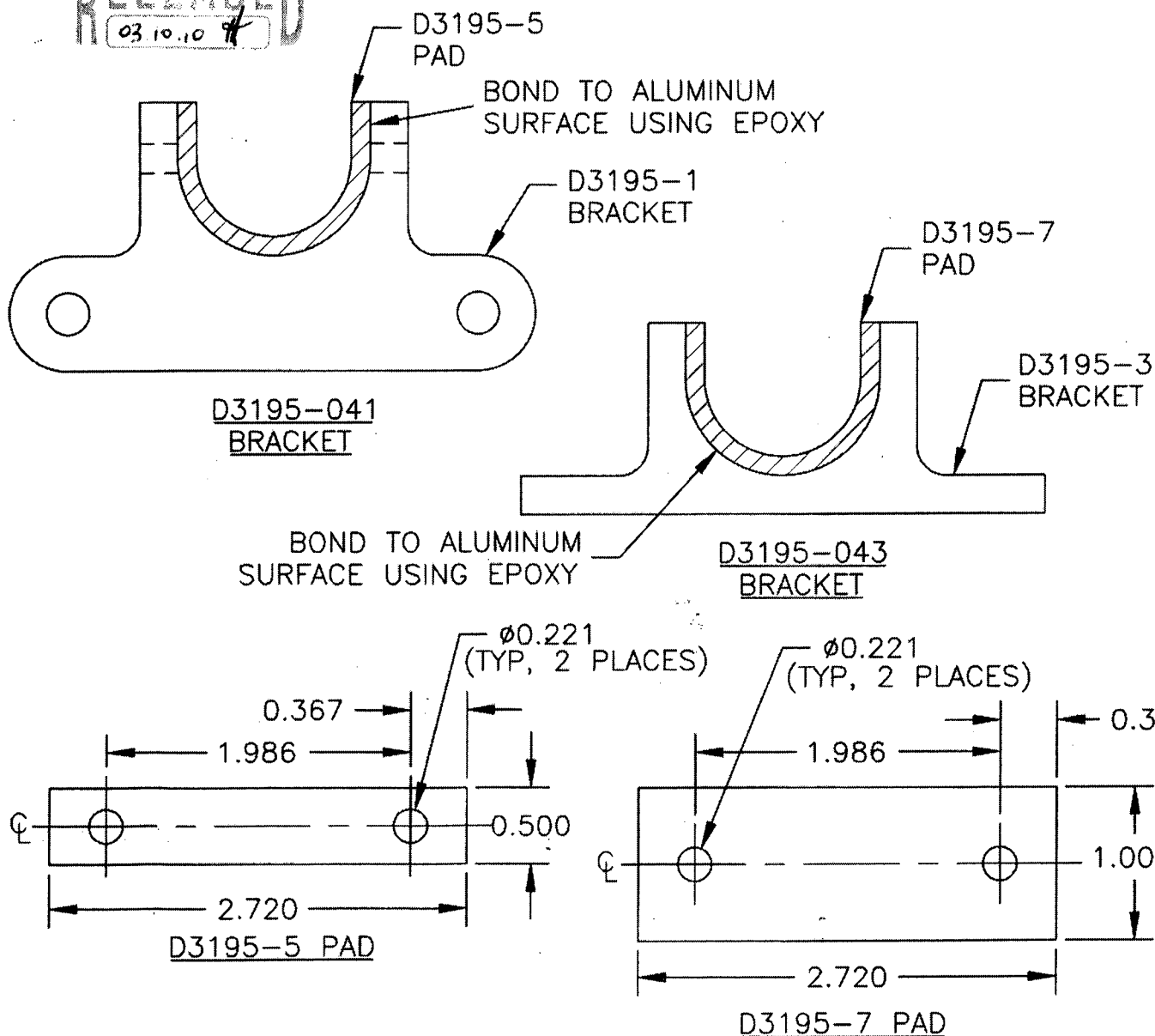
Measured by:	En	Audited by:	J.L	Prototype Approval:	N/A
Date:	05/12/10	Date:	05.12.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. A
CHECKED	#	APPROVED	#	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE	1:1
A	03.06.23	NEW ISSUE			

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

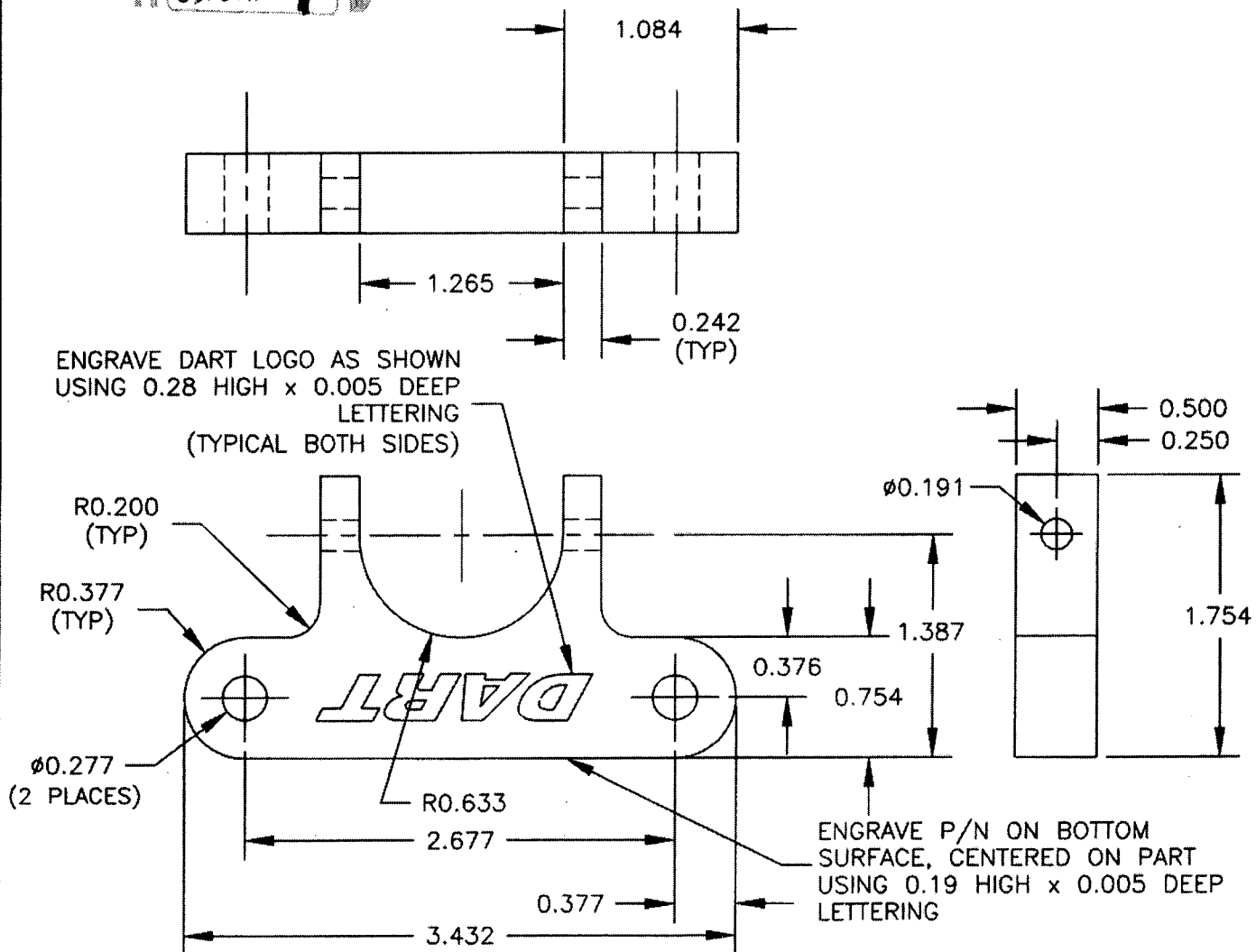
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10**D3195-1 BRACKET**

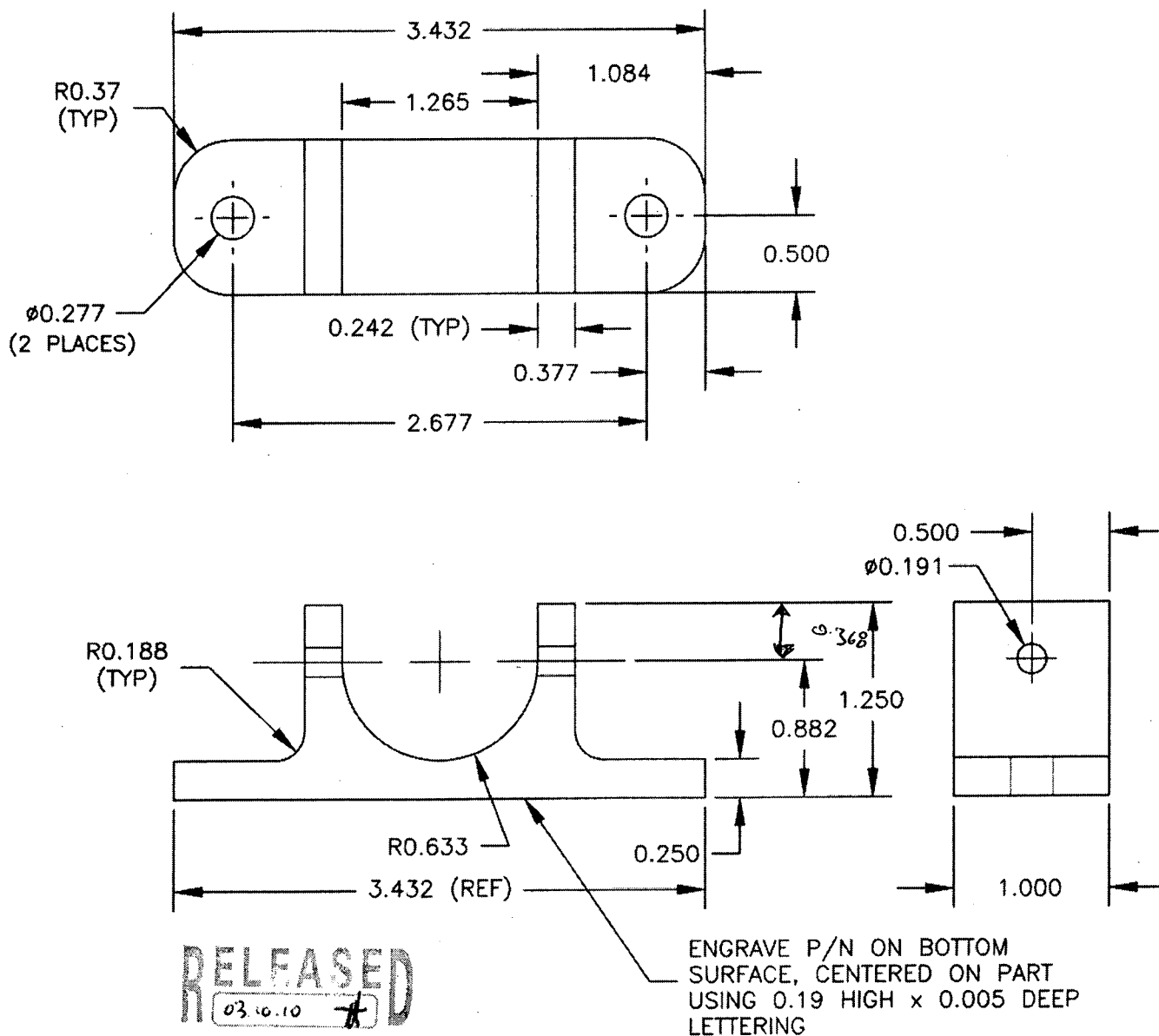
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



RELEASED
03.10.10

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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